Amendments to the Specification:

Please add the following new paragraph before paragraph **[0001]**:

This application is a division of application Serial No. 09/934,701, filed August 22, 2001.

Please replace paragraph **[0029]** with the following amended paragraph:

[0029] As shown in Fig. 4, the arcuate path 44 formed by the track is generally one quarter of a circular path having its center located at a fixed point at which a cutting flame of the torch is continuously aimed. In this example, the center of the circular path is located at a right side, bottom corner 48 of the strand 14. The arcuate path 44 defines a plane perpendicular to a longitudinal axis of the strand 14. The cutting torch 12 (Fig. 3) includes a mechanism for guiding the cutting torch 12 along the track 42. For example, rollers (not shown) operatively engage the track 42. Thus, the cutting torch 12 is adapted to move, as shown in Fig. 4, from the right side 50 of the strand 14 to the left side 52, while gradually rotating from a first orientation 54 perpendicular to the bottom surface 56, to a second

orientation 58 parallel to the bottom surface 56 of the strand 14, the bottom surface 56 extending along a horizontal plane. As the cutting torch 12 moves in the arcuate path 44, the cutting flame 30 is always aimed at the right side, bottom corner 48 of the strand 14 and the molten material thereby flows towards the right-side bottom corner 48. The rate of movement of the cutting torch 12 is dependent on a thickness of the steel, the characteristics of the cutting torch nozzle, the type of fuel and other factors well known in the art. The cutting torch 12 is preferably moved at a predetermined rate required to cut the steel most efficiently. Cutting the steel using this method results in a very small amount of slag forming on and adhering to the bottom corner 48 of the billet 14, rather than the significant amount that forms along the entire lower cut edge 56, as shown in Fig. 2.